

Work Order ID 70363

Page 1

Friday, June 03, 2011 12:44:05 PM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 6/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 6/06/03 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

0.00

Skidtubes

Skidtubes

Memo

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch:

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

11-7-29

DL 11/08/04

BE 11/02/08

BE 11/08/08

DL 11/08/08

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S 11/02/09					
116 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		S 11/08/09					
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		Ac 11.08.10.		1	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BE

①

11/08/11

150 Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 117516 ☐ ☐

Sikaflex expire date: ☐ 12/01/11 ☐

Start: ☐ 11/08/11 ☐ Time: ☐ 4:00 ☐

Finish: ☐ 11/09/11 ☐ Time: ☐ 3:30 ☐

(Adhere for 12 hours)

} DE. 11/08/11

DE 11/08/11

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1	0	BE11/09/06	
170 Skidtubes Skidtubes	Skidtubes Memo 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding	0.00 0.00				1	0	BE11/09/06	

B

11/09/07

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

$h = 3.0''$

8 11/09/07

(4)



QC

Memo

0.00

$L = 4.7''$

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ M112060 BE 11/09/07

3-Grind cross bolt welds flush as per Dwg D3274.

BB 11/09/08

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

BE 11/09/08

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulorlos

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Sulorlos

(H)

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

IX JML 11/09/08

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
320 OF
8:30

0.00

K Ø M 11/09/12

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 Ø M 11/09/13

250

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/R ☐ A ☐ LPS-3 ☐ M 109956

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R ☐ Sikaflex-291 ☐ 11/18/09Sikaflex expire date: ☐ 12/01

1 Ø M 11/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

11 09 13 (1)

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 1118393Sikaflex expire date: ☐ 12/01

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 12/14

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 1118393Sikaflex expire date: ☐ 12/01

1 8 14/06/13

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00

S 10/1/13

②



QC

Memo

0.00

Quality Control

290

Identify as per dwg & Stock Location: _____

0.00

MP 72488

11/9/13



Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

11/9/14



QC

Memo

0.00

Quality Control

MF 11-09-14

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, June 03, 2011 12:44:02 PM

Page 1

Work Order ID: 70363

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 6/3/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190 		Manufactured	No			110	Each	34.4000	1	1			
Extrusion Round 3" 206													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				HALL	34.4								
				59874	34.4								
D3285-1 		Manufactured	No			110	Each	106.0000	1	1			
Cap													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG002	106								
				52511	59								
				52647	47								
D3282-041 		Manufactured	No			150	Each	6.0000	1	1			
Float Web (206L/407)													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				LG	6								
				65293	2								
				66363	4								

11-7-29
 BEU/08/08

11/08/29

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Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 6/3/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No

190 Each

75.0000

12

12



Cross Bolt Spacer



BEN/09/07
B72704 *12

Location

Loc Qty

Loc Code

LG	63	
68224	63	
LG001	12	
65317	1	
68507	11	

D3275-1 Manufactured No

190 Each

214.0000

12

12



Crossbolt Spacer



BEN/09/07

Location

Loc Qty

Loc Code

LG	34	
- 67767	34	
LG002	180	
66930	108	
68946	72	

CR3212-4-03 Purchased No

250 Each

1,234.000

2

2



Cherry Rivet



11/09/13

Location

Loc Qty

Loc Code

FP-B	2	
110139	2	
ST311	1232	
114859	1232	

12

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 6/3/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No

250 Each

62.0000

1

1



11/09/13

Nut Plate

Location

Loc Qty

Loc Code

ST053

62

33842

18

67605

44

x1

CCR264SS3-3 Purchased No

250 Each

587.0000

2

2



11/09/13

Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

585

117086

85

117849

500

x2

ALS4-1032-130 Purchased No

250 Each

1,920.000

78

78



11/09/13

Insert

Location

Loc Qty

Loc Code

ST281

8

117331

8

ST282

1912

117717

1912

M118312

x78

D3536-15 Manufactured No

270 Each

19.0000

1

1



11/09/13

Gasket

Location

Loc Qty

Loc Code

FP011

19

66559

19

1372881

x1

W/O:		WORK ORDER CHANGES					
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Start Date: 6/3/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-23	Manufactured	No	270	Each	17.0000	1	1
							<u>21 11/09/13</u>
Gasket							

Location

Loc Qty

Loc Code

FP011

17

1369902

x1

43406

1

66560

16

D3536-35	Manufactured	No	270	Each	32.0000	1	1
							<u>21 11/09/13</u>
Gasket							

Location

Loc Qty

Loc Code

FP012

32

371587

x1

66237

1

67599

5

69755

26

D3536-39	Manufactured	No	270	Each	37.0000	1	1
							<u>21 11/09/13</u>
Gasket							

Location

Loc Qty

Loc Code

FP015

37

66241

11

69760

26

v1

D3535-15	Manufactured	No	270	Each	13.0000	1	1
							<u>21 11/09/13</u>
Wearshoe							

Location

Loc Qty

Loc Code

FP018

13

66558

7

68358

6

1369931

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

Friday, June 03, 2011 12:44:02 PM

Work Order ID: 70363

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 6/3/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

270 Each 25.0000 9 9



Wearpad



ul 11/09/13

Location

Loc Qty

Loc Code

FP016

4

68944

4

B70687

x4

FP017

21

63313

2

66935

4

68944

15

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 80 80



washer

M118354



(x80) ul 11/09/13

AN960C416 NAS1149C0463 Purchased No

270 Each 0.0000 1 1



washer

M115358



(x1) ul 11/09/13

D3672-1 Manufactured No

270 Each 1,188.000 2 2



Phenolic Washer



ul 11/09/13

Location

Loc Qty

Loc Code

ST074

1188

64177

688

66821

500

x2

Friday, June 03, 2011 12:44:02 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 03, 2011 12:44:02 PM

Work Order ID: 70363

Parent Item: D206-642-541


Parent Item Name: Replacement Skidtube

Start Date: 6/3/2011

Required Date: 6/14/2011


Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 270 Each 2,217.000 80 80

 BOLT


Location	Loc Qty	Loc Code
ST350	2217	
117094	715	1118628
117313	2	
117688	800	
117795	500	
117872	200	

all 1109113

AN4C5A Purchased No 270 Each 522.0000 1 1

 BOLT

Location	Loc Qty	Loc Code
FP-B	111	
112243	111	
ST345	411	
112243	411	

all 1109113

D2646 Manufactured No 270 Each 28.0000 1 1

 Aft Cap

Location	Loc Qty	Loc Code
FP006	27	
62678	27	1371070
FP-4	1	
69019	1	

all 1109113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Friday, June 03, 2011 12:44:02 PM

Work Order ID: 70363



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 6/3/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

270

Each

26.0000

1

1



eel u/06/11/13

Ring

Location

Loc Qty

Loc Code

ST420

19

62961

8

66387

11

ST473

7

66945

7

0370773

KL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED
07.02.12 **[Signature]**
DEO ATTACHED

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

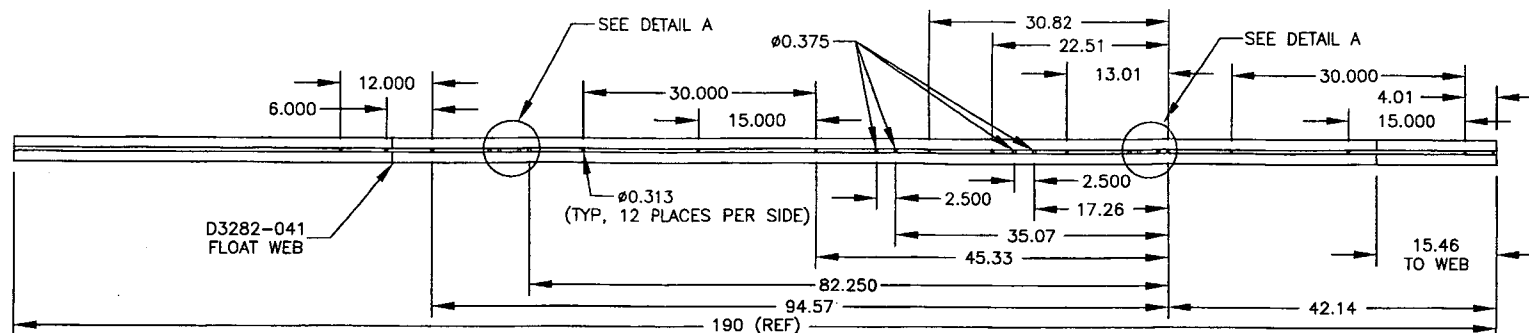
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

CL11106/03
W/D: 70363

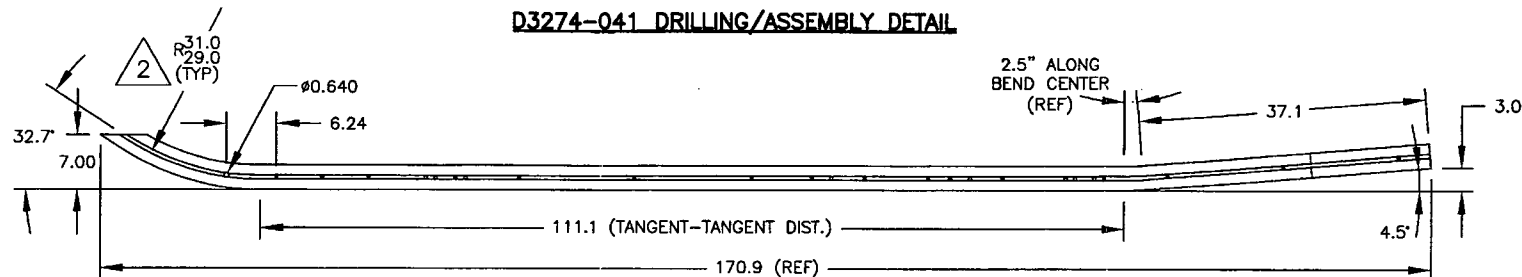
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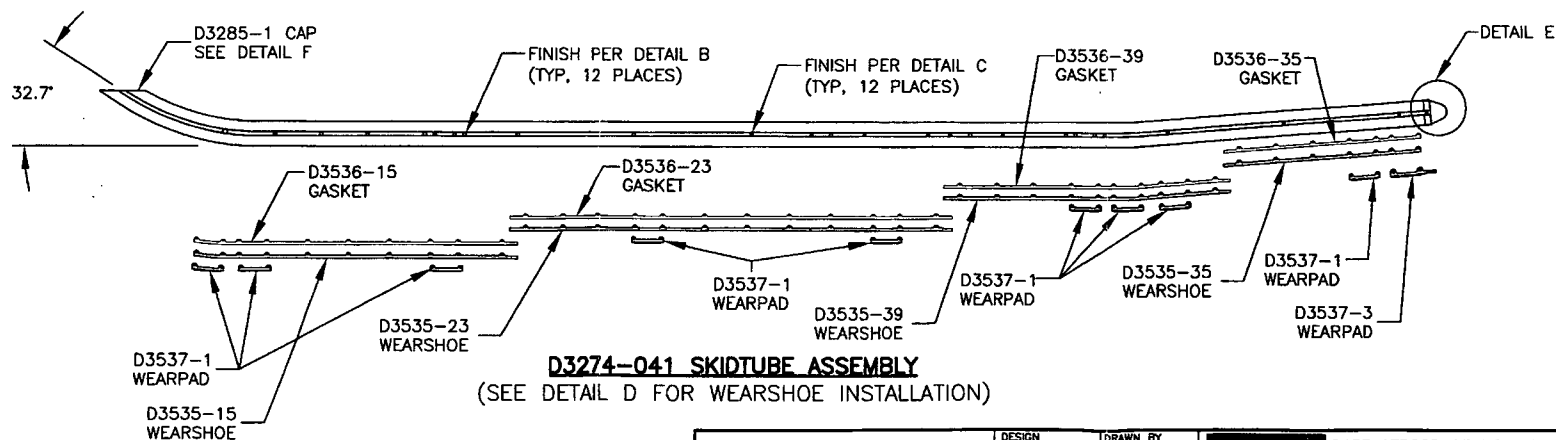
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

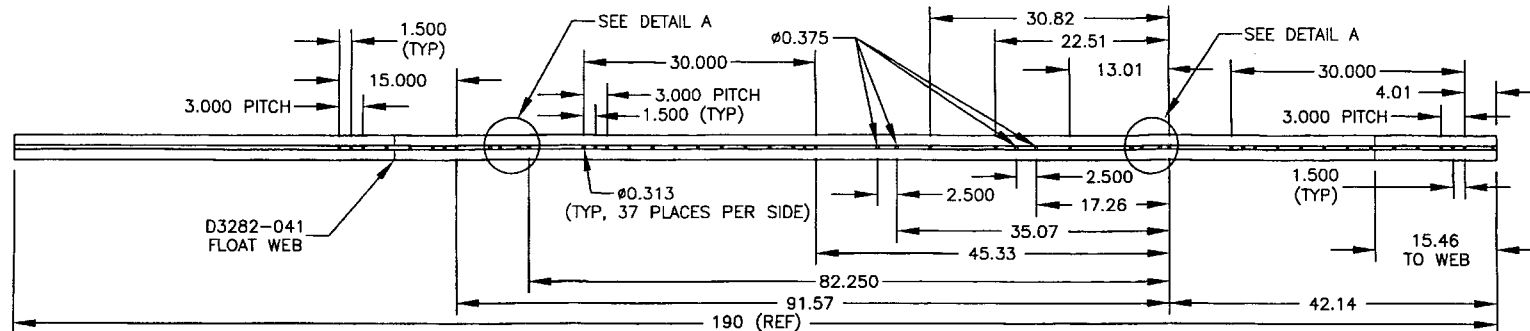
07.02.12

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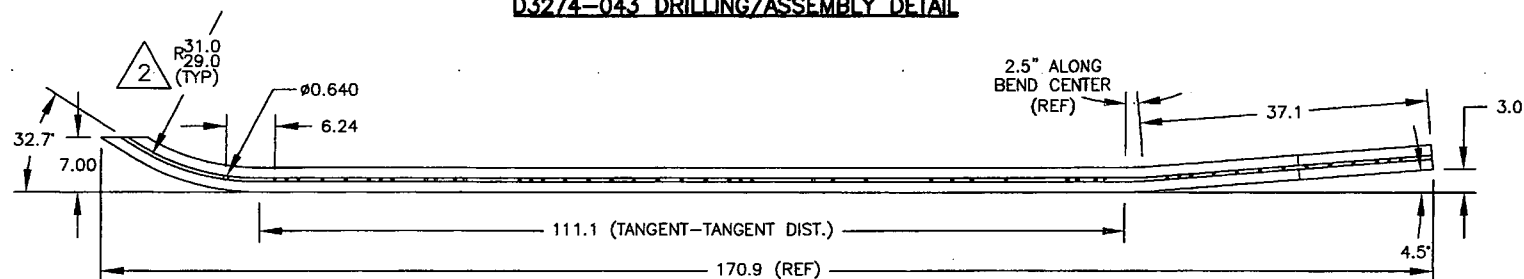
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DESIGN CP	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED H	APPROVED H	DRAWING NO. D3274
DATE 06.12.19	TITLE SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

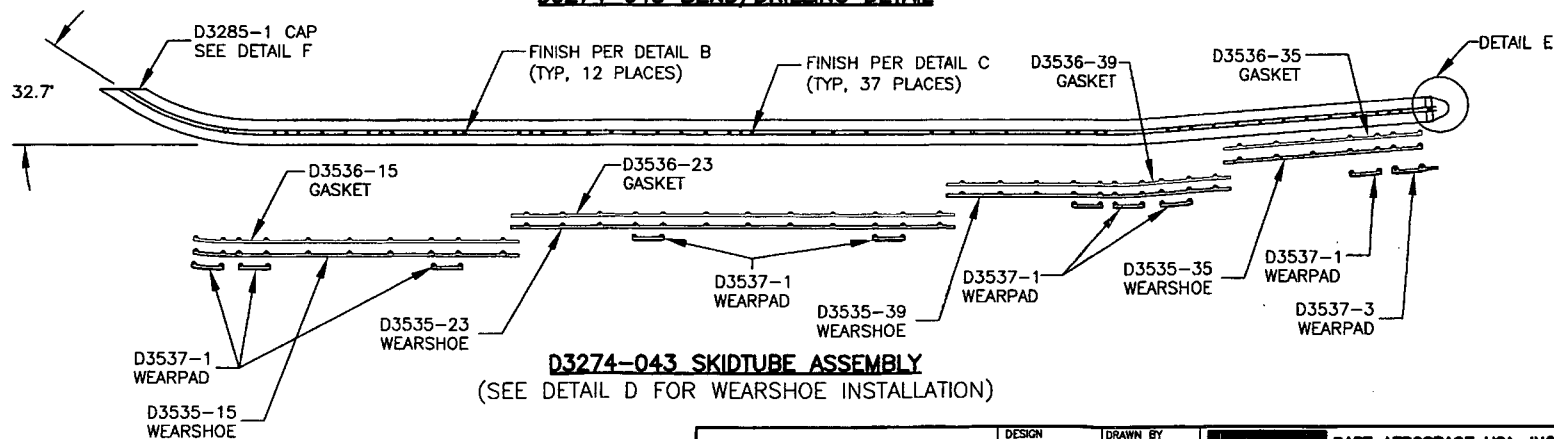
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



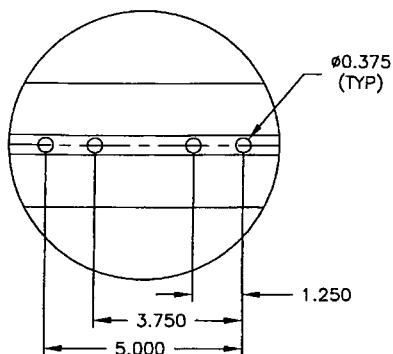
D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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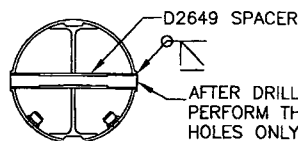
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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		REV. D SHEET 3 OF 4 SCALE 1:15

DETAIL A: DRILL DETAIL

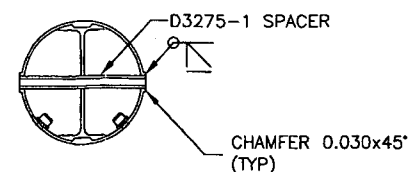


DETAIL B FOR Ø0.375 HOLES ONLY

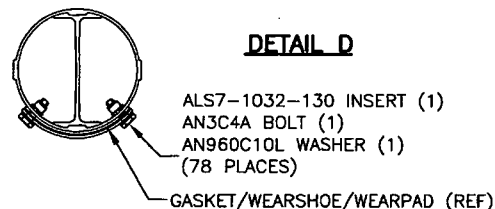


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

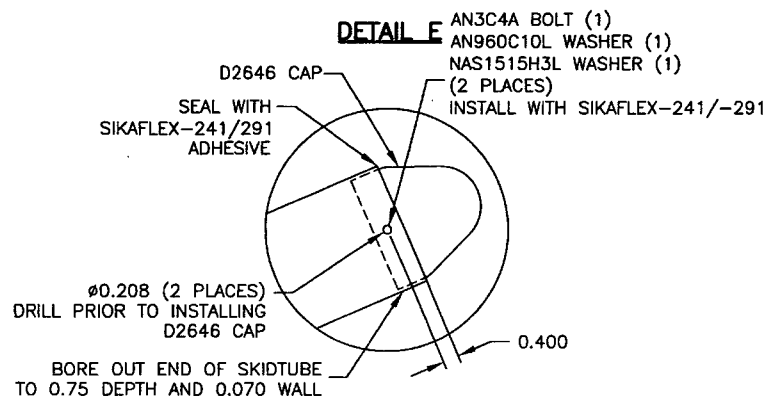
DETAIL C FOR Ø0.313 HOLES ONLY



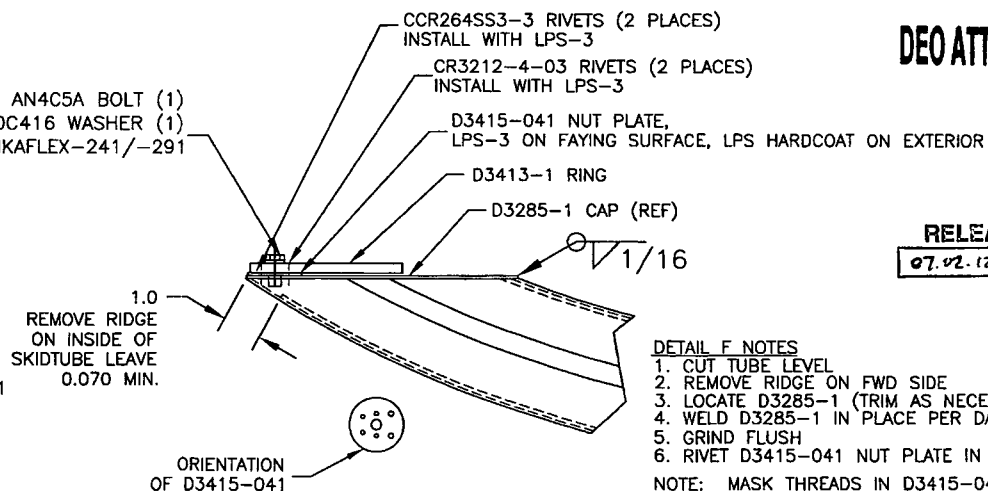
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DEO ATTACHED

RELEASED

07.02.12

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		CP	PH	DRAWING NO.	REV. D
		CHECKED	APPROVED	D3274	SHEET 4 OF 4
		DATE		TITLE	SCALE
		06.12.19		SKIDTUBE ASSEMBLY	1:3

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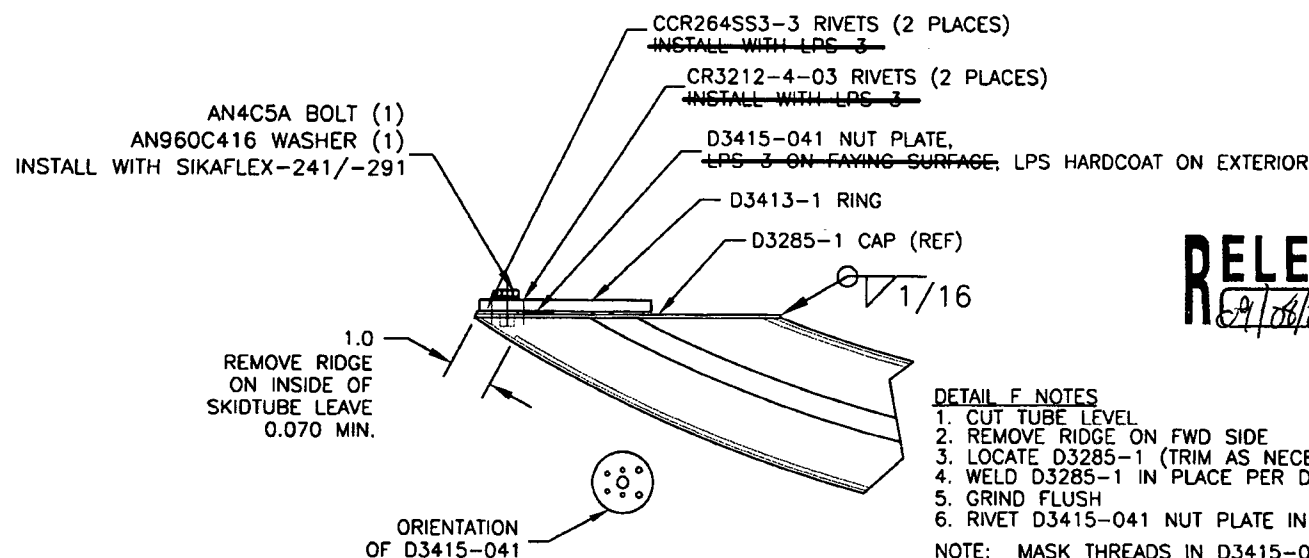
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

NO. 261

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B69449
Part number: D206 642 541
Description: 206
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Sal Lewis Date of Test Coupon 11-08-11
Welder Barclay Elliott Date of Test Coupon 11-08-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld